

Work Order ID 71678

Thursday, July 07, 2011 12:12:28 PM



Page 1

Item ID: D3259-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 7/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

CD

Date: 11/07/07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3259

Rev B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

ES 11/09/20 (4)

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3259-041 as per Dwg D3259. □Note:Keep .040" Gap all around door.

ES 11/09/20 (4)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*S. Mark**(49)**ay*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71678

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Page 2

Item ID: D3259-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 7/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location 5182.

0.00



Packaging

Memo

0.00

Packaging

4x 11-09-20

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/21
MF
11-09-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 71678

Parent Item: D3259-041

Parent Item Name: Access Panel Assembly



Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC IPP REV
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-5 Hinge 9.9"		Manufactured	No			110	Each	14.0000	1	4			
<div> <div>Location</div> <div>ST037</div> <div>47187</div> <div>47773</div> </div> <div> <div>Loc Qty</div> <div>14</div> <div>2</div> <div>12</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3259-1 Panel		Manufactured	No			110	Each	1.0000	1	4			
<div> <div>Location</div> <div>ST180</div> <div>60082</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3259-3 Dupler		Manufactured	No			110	Each	1.0000	1	4			
<div> <div>Location</div> <div>ST180</div> <div>60083</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3259-5 Spacer		Manufactured	No			110	Each	3.0000	1	4			
<div> <div>Location</div> <div>ST180</div> <div>60084</div> </div> <div> <div>Loc Qty</div> <div>3</div> <div>3</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

EP 11/09/20

EP 11/09/20

B 71630 (4x)

EP 11/09/20

B 71681 (4x)

EP 11/09/20

B 71629 (4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 07, 2011 12:12:26 PM

Work Order ID: 71678

Parent Item: D3259-041

Parent Item Name: Access Panel Assembly

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

D3259-7

 Door

Manufactured No

110

Each

1.0000

1



4

EP 11/09/20

B71632 (4x)

Location

Loc Qty

Loc Code

ST180

1

58751

1

D3260-1

 Spring

Manufactured No

110

Each

0.0000

2



8

B71631 (8x)

EP 11/09/20

D3973-5

 Receptable, Rigid, DZUS

Manufactured No

110

Each

68.0000

2



8

EP 11/09/20

Location

Loc Qty

Loc Code

ST101

68

58759

68

D3974-20

 Stud, Wing Head; 5/16 DZUS

Manufactured No

110

Each

91.0000

2



8

EP 11/09/20

Location

Loc Qty

Loc Code

ST103

91

58761

66

61160

25

MS20426AD4-4

 Rivet

Purchased No

110

Each

2,452.000

4



16

EP 11/09/20

Location

Loc Qty

Loc Code

ST317

2452

116188

2452

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Thursday, July 07, 2011 12:12:26 PM

Page 3

Work Order ID: 71678

Parent Item: D3259-041

Parent Item Name: Access Panel Assembly

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

MS20470AD3-4 Purchased

No

110

Each

9,156.000

36

144



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

9156

111477

8332

15541

824

144

MS20470AD3-5 Purchased

No

110

Each

3,892.000

10

40



Rivet

Location

Loc Qty

Loc Code

ST319

3892

104817

3030

9682

862

40

8 A 11.09.20
A3972-S

Qty 2

B: M115178

ES 11/09/20

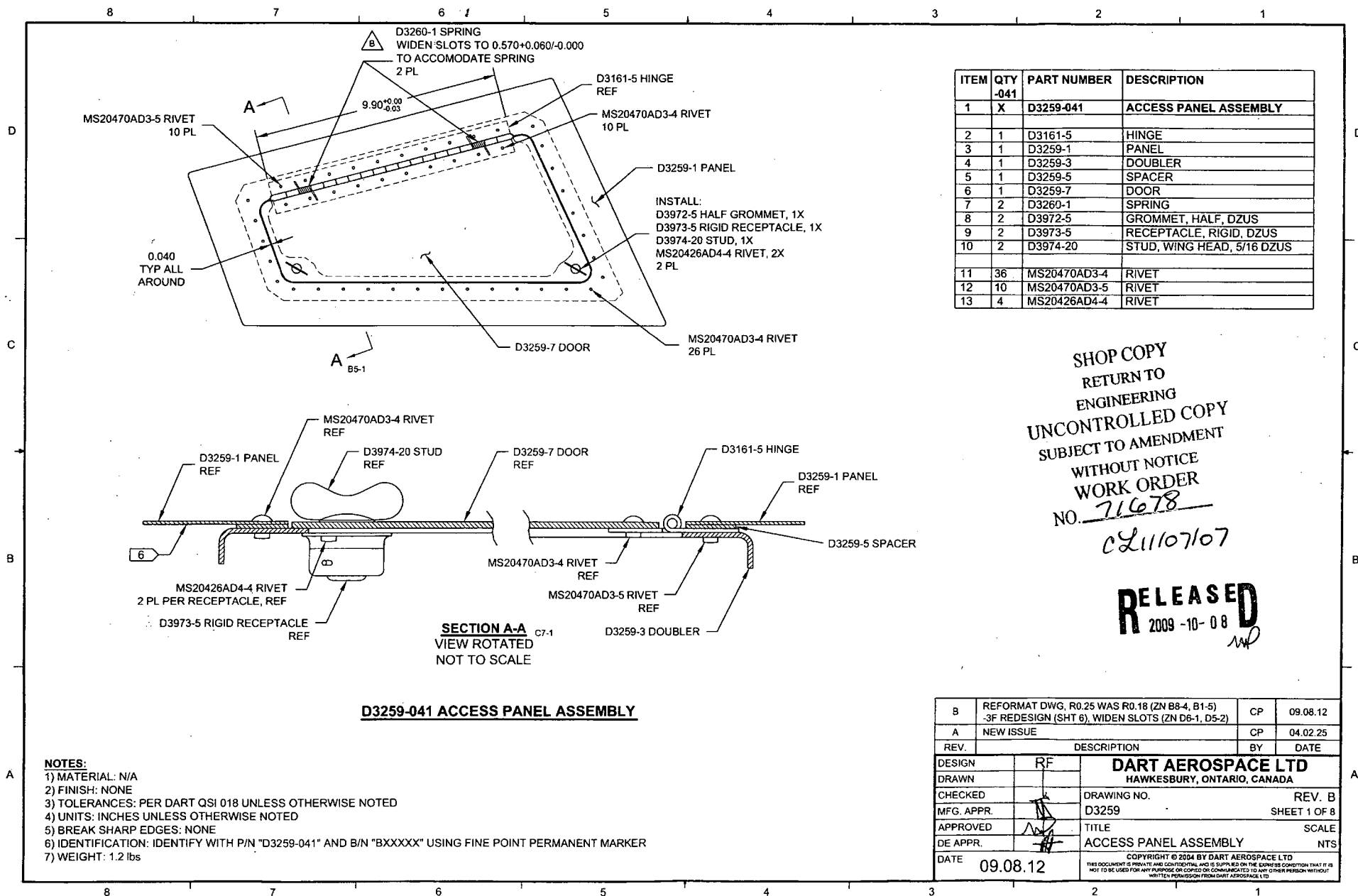
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

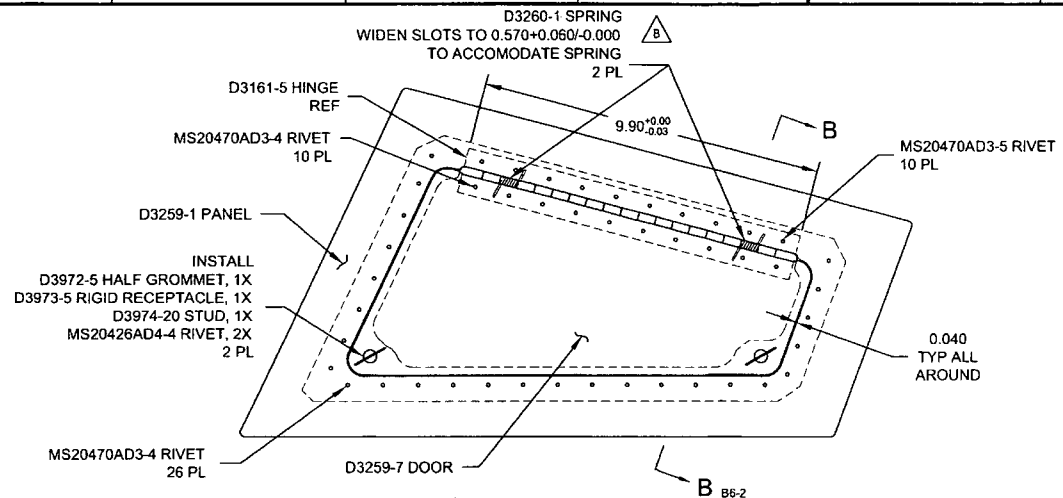
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

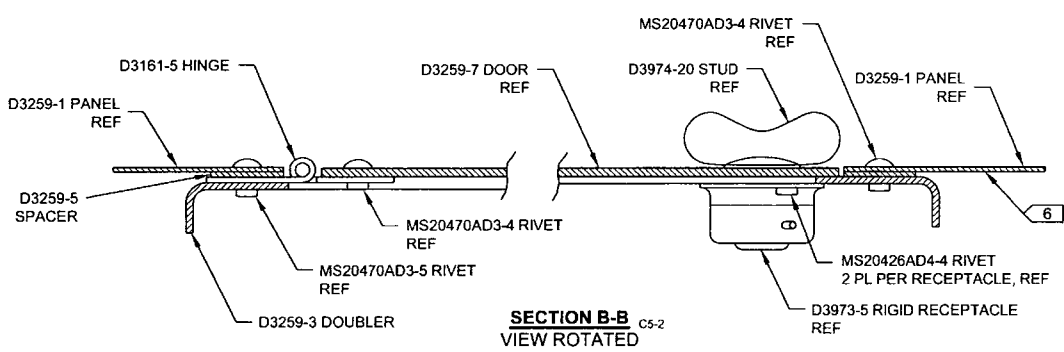
NOTE: Date & initial all entries



8 7 6 5 4 3 2 1



ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3259-042	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-4	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET



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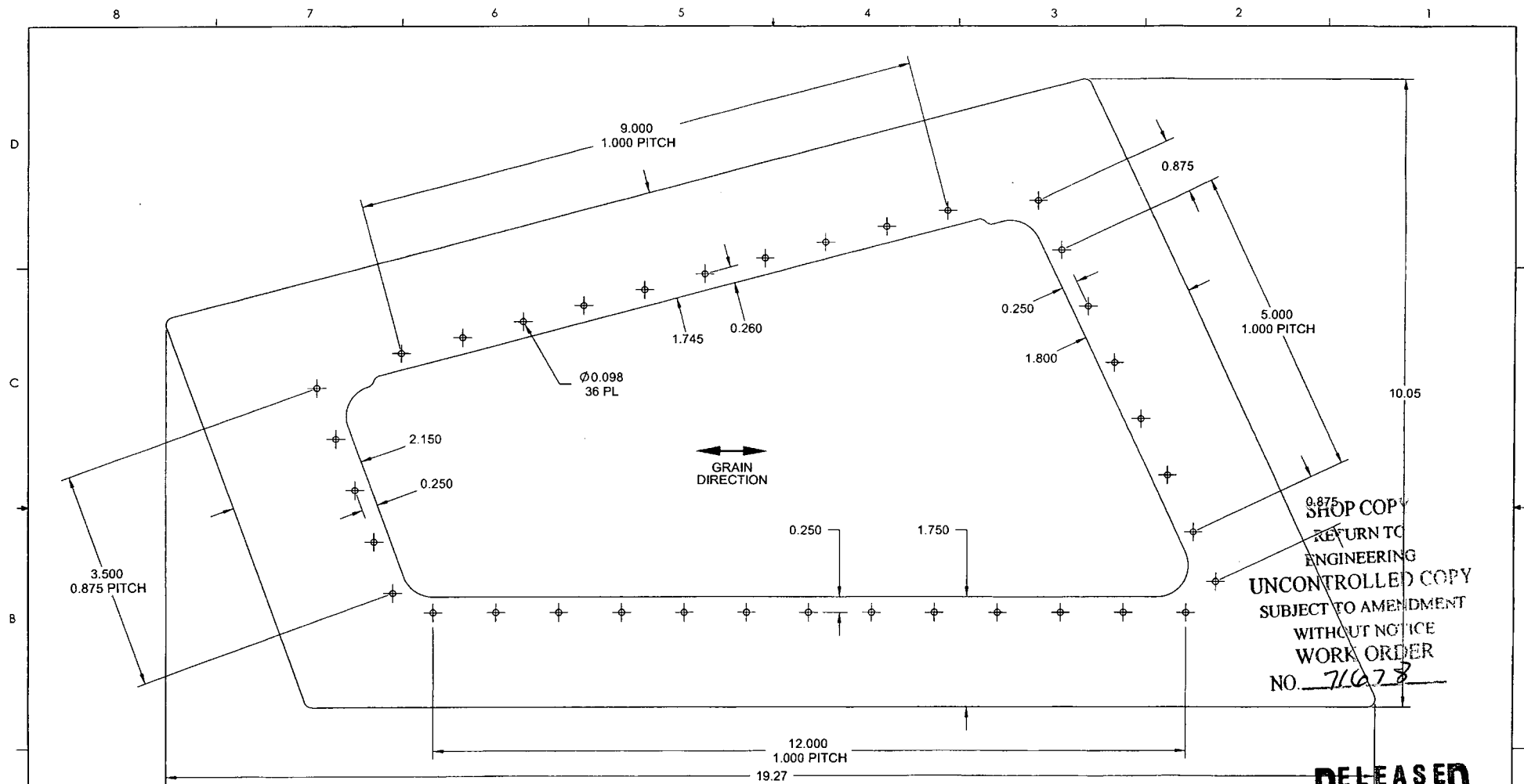
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2009-10-08
ND

D3259-042 ACCESS PANEL ASSEMBLY

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: NONE
 - 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-042" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
 - 7) WEIGHT: 1.2 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D3259	SHEET 2 OF 8
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APPROVED		ACCESS PANEL ASSEMBLY	NTS
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DATE	09.08.12		

8 7 6 5 4 3 2 1



D3259-1 PANEL

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.25 lbs
- 8) MAKE PER DWG FILE "D3259-1B.DXF"

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NNO

8 7 6 5 4 3 2 1

D

C

B

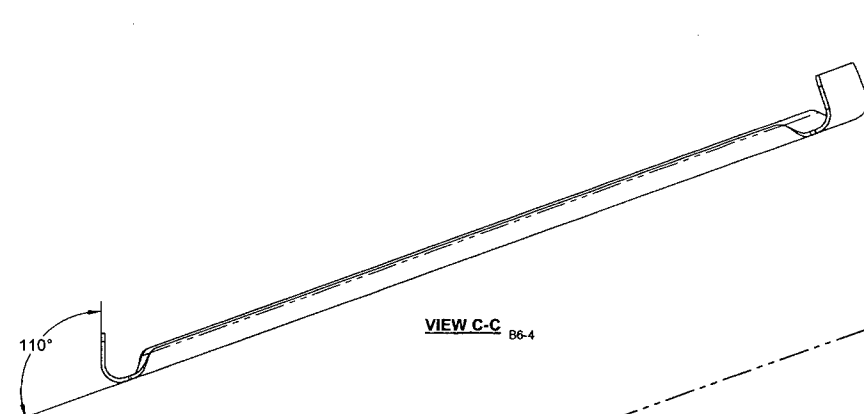
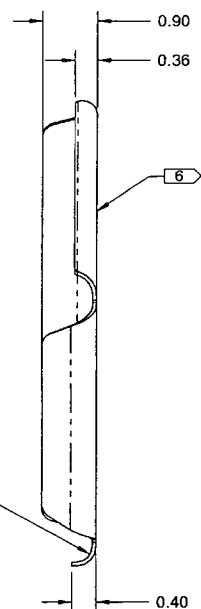
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D

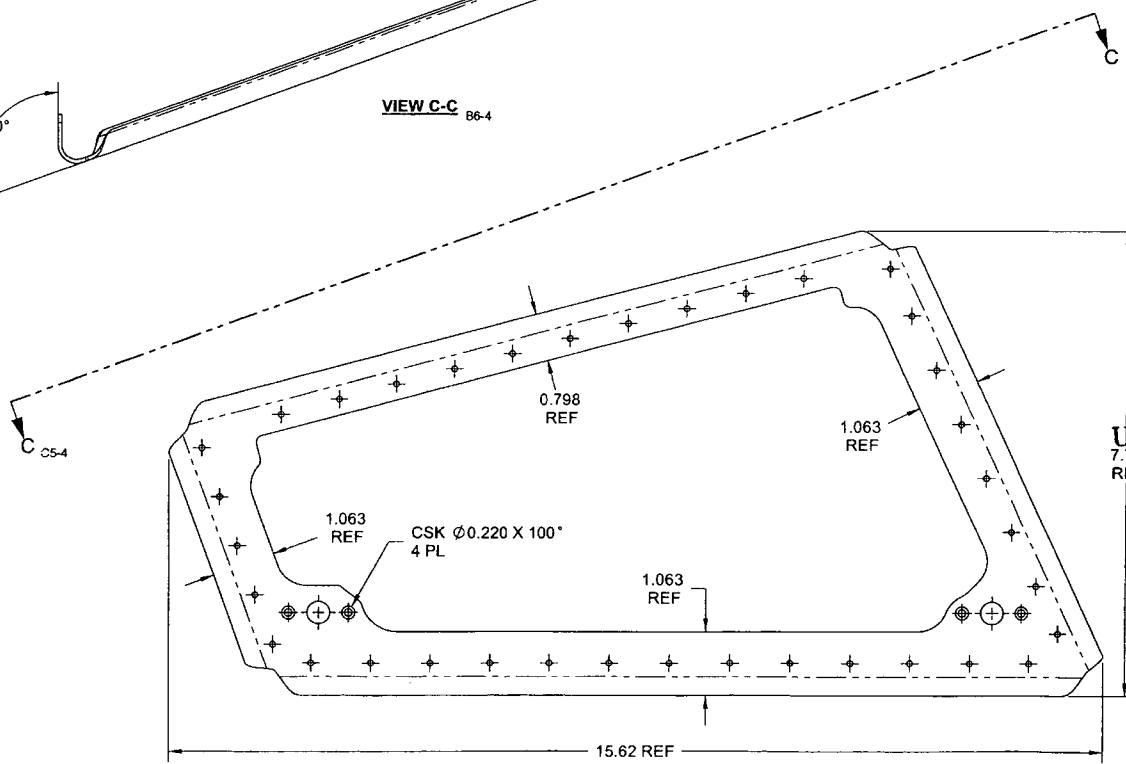
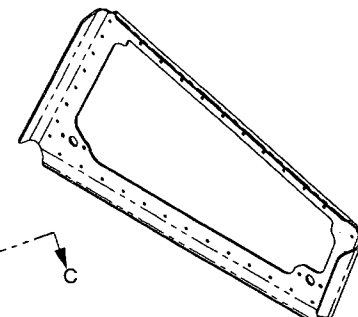
C

B

A



VIEW C-C B6-4



D3259-3 DOUBLER

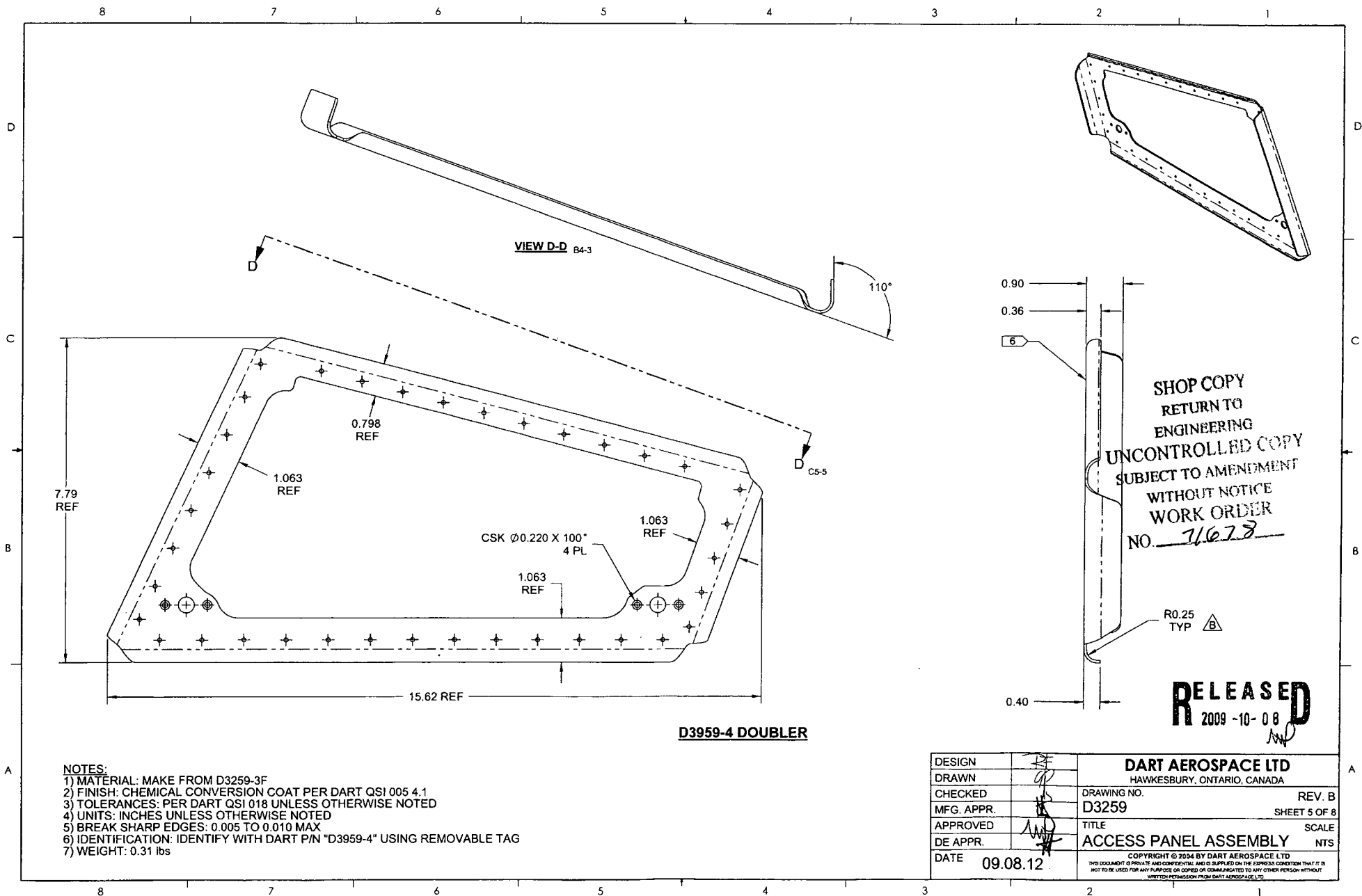
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NO. 71678

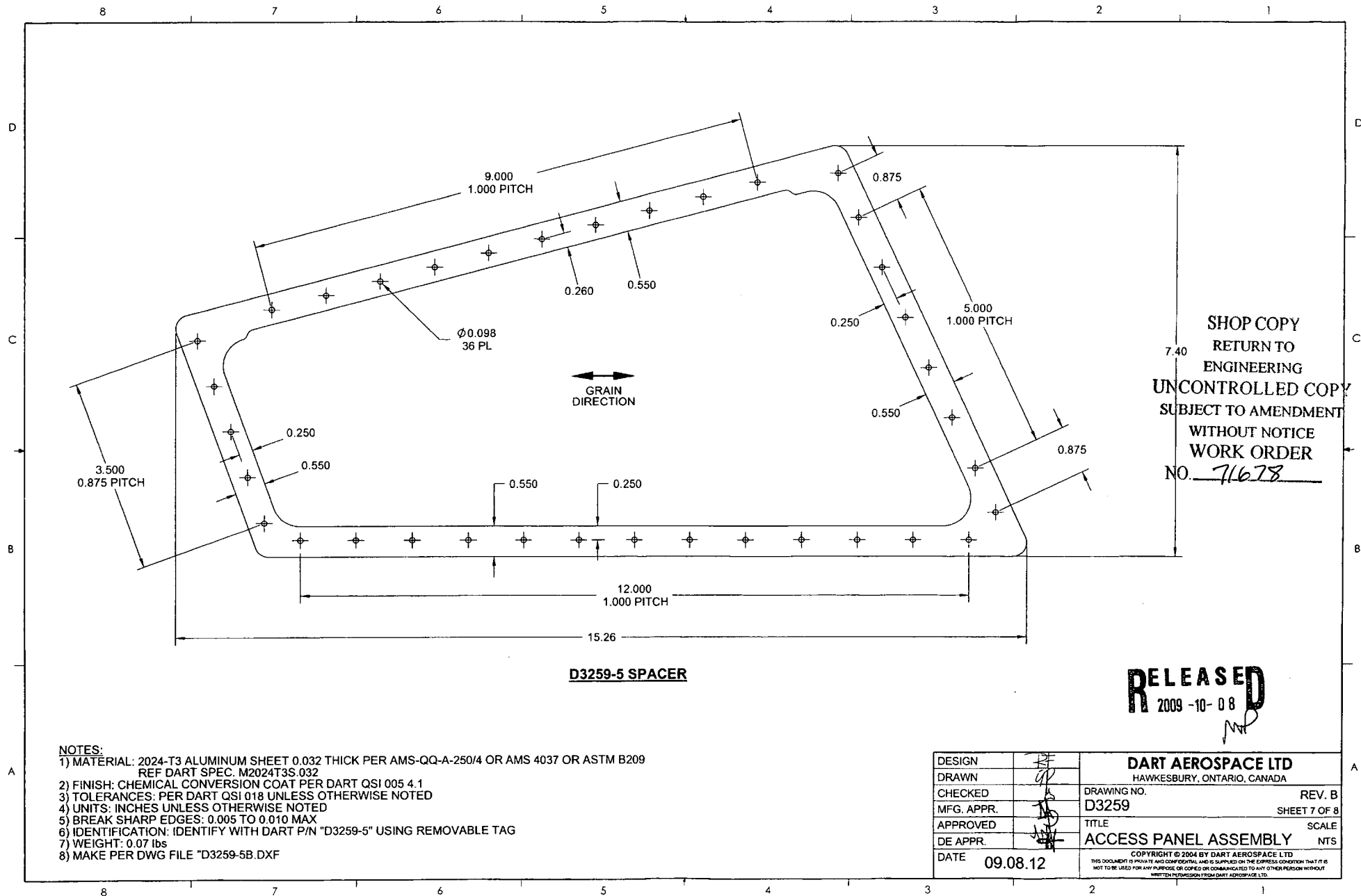
RELEASED
2009-10-08

- NOTES:
- 1) MATERIAL: MAKE FROM D3259-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3" USING REMOVABLE TAG
 - 7) WEIGHT: 0.31 lbs






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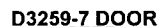
8 7 6 5 4 3 2 1





NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.032
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-5" USING REMOVABLE TAG
7) WEIGHT: 0.07 LBS
8) MAKE PER DWG FILE "D3259-5B.DXF"

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO. D3259	REV. E
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2009-10-08

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC. M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-7" USING REMOVABLE TAG
- 7) WEIGHT: 0.35 lbs
- 8) MAKE PER DWG FILE "D3259-7B.DXF"

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